Date: Friday, 24/10/2008 3:31:47 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: END FITTING ASS'Y
Job Number	: 42951		
Estimate Number	: 13345		
P.O. Number	:	**Part Number**	: D3763041
This Issue	: 24/10/2008 **S.O. No.** :	**Drawing Number**	: D3763 REVB
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 42950	**Material**	:
Written By	:	**Due Date**	: 03/11/2008 **Qty:** 10 **Um:** Each
Checked & Approved By	: JLD 08-10-24		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

2.0	D37631	End Fitting

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
End Fitting
batch: B42732 =(10) SP 09.02.04

3.0	D37633	Tube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Tube
batch: B44340 =(10) SP 09.02.04

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-make a 0.063" chamfer on D3763-1 fitting before ass'y

2-assemble as per dwg D3763 using locating pin DT9039
**********ensure locating pin is in 0.221" hole**********

(10x)

3-weld as per dwg D3763 QSI004
Alum. rod Batch: T108855 SP 09-02-04

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 3:31:47 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** END FITTING ASS'Y

Job Number: 42951 **Part Number:** D3763041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	09-02-05 (10)
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	09/02/05 (10)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	09/02/05 (10)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	04-02-06 (10)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify wiith Dart part # using a fine point permanent marker and Stock Location:_____	09/2/06 (10)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	09/02/06 (10)

Job Completion 09/02/06

Form: rprocess

Dart Aerospace Ltd

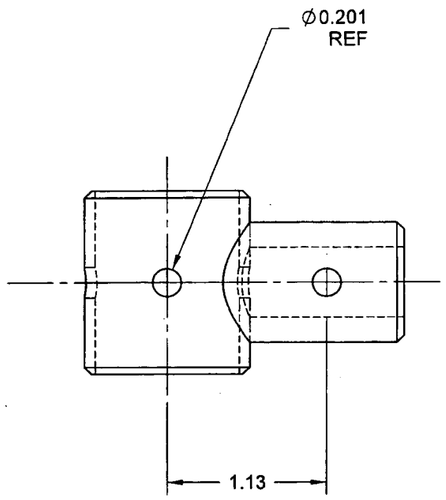
W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

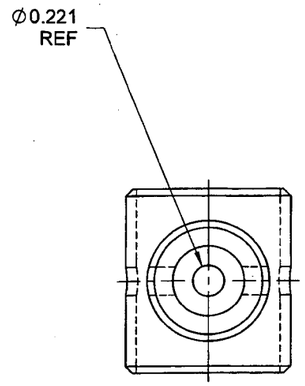
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

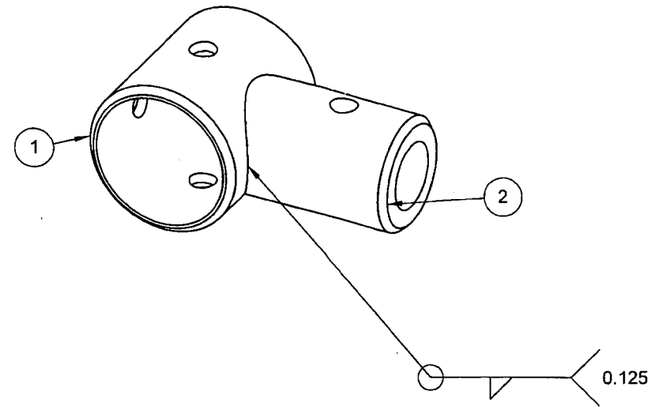
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

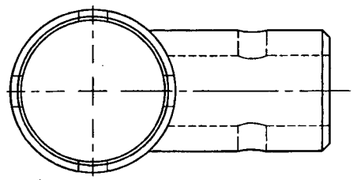
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries









ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42951

RELEASED
08.07.08 MP

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		DRAWING NO. D3763 REV. B
MFG. APPR.		SHEET 1 OF 9
APPROVED		TITLE END FITTING SCALE NTS
DE APPR.		
DATE	08.06.23	

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